

# Work Order ID 51409

August 21, 2009 10:17:34 AM



Page 1

Item ID: D3529-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bearpaw

Start Date: 8/21/09 Start Qty: 16.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

09/08/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3529

Rev A

18

110

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3529-1BLANK

B 9-8-27

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining! 12-Machine as per Folio FA645 and Dwg D3529! 13-Deburr

Y.A 09/08/29

18

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Y.A 09/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* NOTE: Date & initial all entries

**Work Order ID 51409**

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Page 2

Item ID: D3529-1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

9/20/08/31

18 0

150

Identify as per dwg &amp; Stock Location: PDP

0.00



Packaging

Memo

0.00

Packaging

51001

P 9/8/01 (18)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/01 AD

P 09-9-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

August 21, 2009 10:17:34 AM

Work Order ID: 51409

Parent Item: D3529-1RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 8/21/09

Required Date: 8/31/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	392.9220	21.3053			



UHMW 1" Black



B 9-8-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	271.812	
112186	271.812	
Main Warehouse		
ST	121.11	
108762	18	
109186	5	
110520	8	
110721	24	
111354	66.11	

111354

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51409
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3529-1
<b>Inspection Dwg:</b> D3529 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

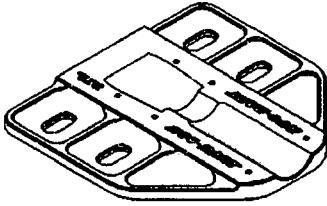
☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500	✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.071 x 45°	✓			
C	R0.25	+/-0.030	R0.250	✓			
D	0.250	+/-0.010	0.252	✓			
E	0.625	+/-0.010	0.626	✓			
F	0.950	+/-0.010	0.957	✓			
G	1.63	+/-0.030	1.623	✓			
H	12.14	+/-0.030	12.14	✓			
I							
J	5.70	+/-0.030	5.70	✓			
K	0.375	+/-0.010	0.374	✓			
L	0.525	+/-0.010	0.523	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.136 x 45°	✓			
N	R0.50	+/-0.030	R0.50	✓			
O	12.76	+/-0.030	12.76	✓			
P	3.38	+/-0.030	3.380	✓			
Q	3.75	+/-0.030	3.751	✓			
R	5.187	+/-0.010	5.185	✓			
S	5.25	+/-0.030	5.250	✓			
T	7.13	+/-0.030	7.130	✓			
U	Ø0.260	+0.006/-0.001	Ø0.260	✓			
V	0.30	+/-0.030	0.310	✓			
W	0.93	+/-0.030	0.926	✓			
X	1.30	+/-0.030	1.30	✓			

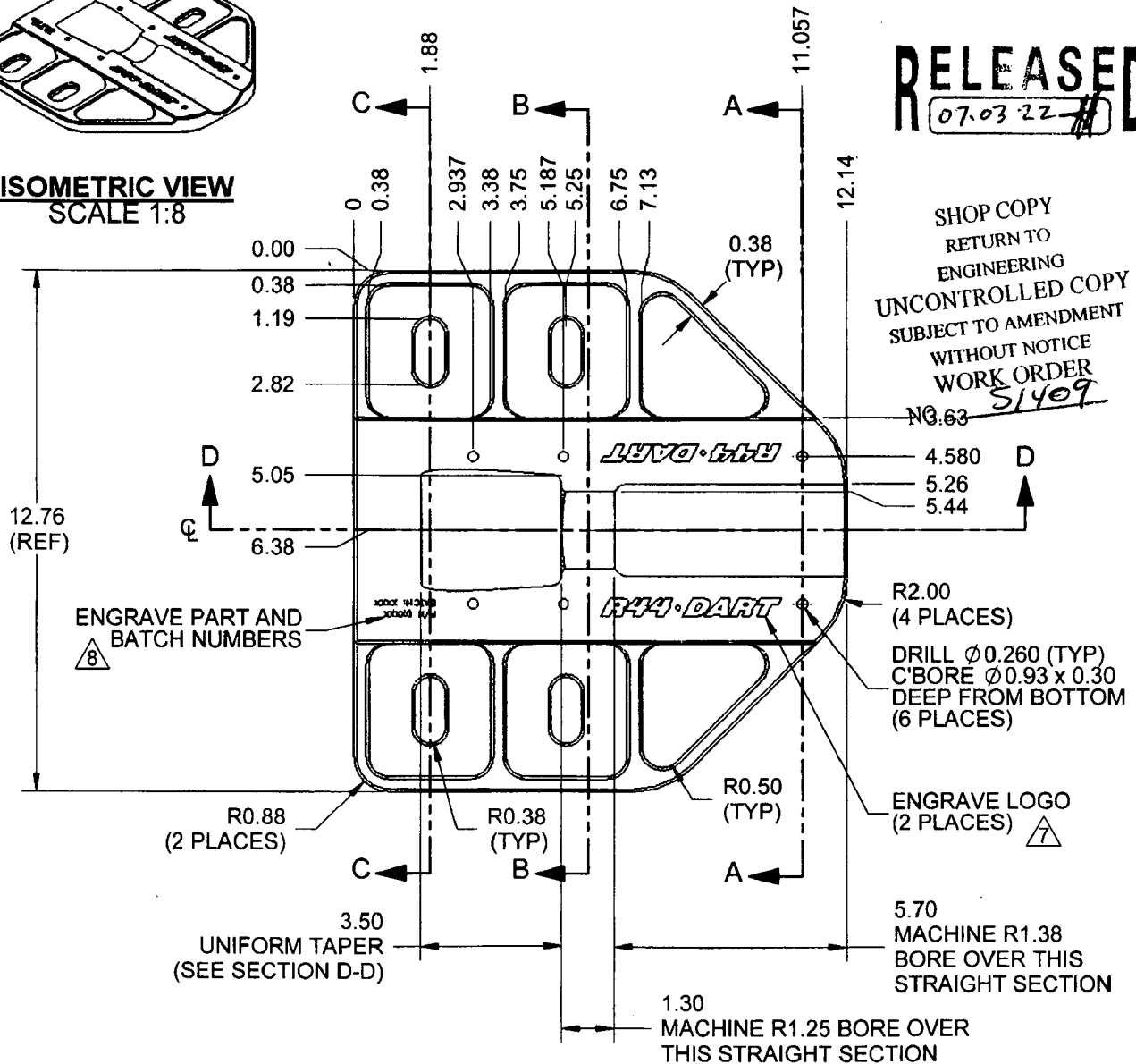
<b>Measured by:</b> J.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/08/29	<b>Date:</b> 09/08/31	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW SCALE 1:4	
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



**ISOMETRIC VIEW**  
**SCALE 1:8**



**D3529-1 R44 BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)  
2) FINISH: NONE  
3) PART IS SYMMETRIC ABOUT C  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX  
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN  
8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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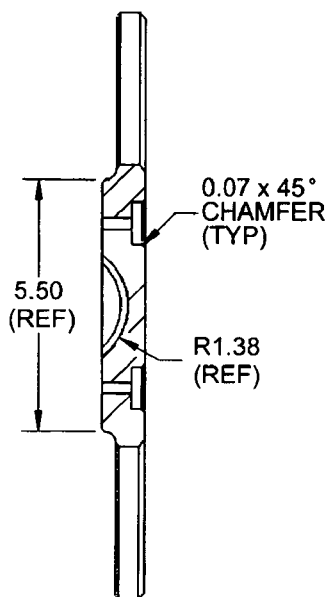
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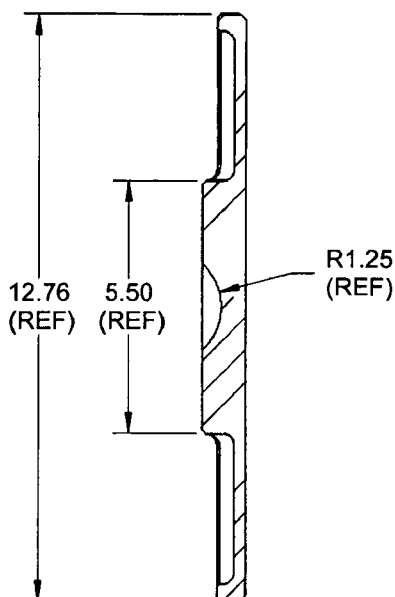


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

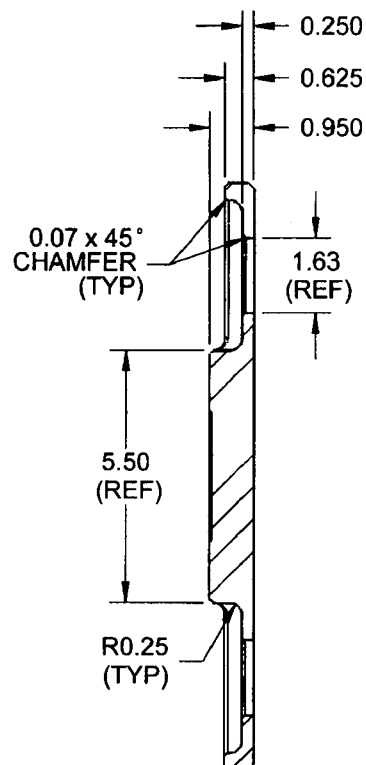
RELEASED  
07.03.22



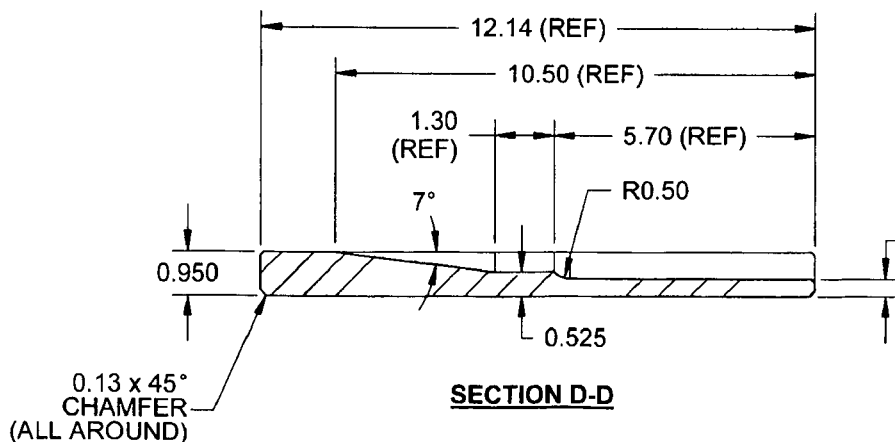
**SECTION A-A**



**SECTION B-B**



**SECTION C-C**



**SECTION D-D**

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NO. 31409

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